

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018073**Date Inspected:** 16-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # CROSSBEAM CB16

This QA inspector performed random visual inspection of Crossbeam CB16. This QA inspector observed that various weld have undercut and undersize welds. This QA marked the affected areas and informed ZPMC Quality Control (QC) indentified as Mr. Zheng Zhi Wei of this issue. Mr. Zheng Zhi Wei informed this QA that the repair would be corrected in a manner compliant with the contract documents. See attached pictures.

OBG # BAY 6

This QA observed ZPMC qualified welding personnel identified as 048659 / 049769 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CB3002J-001-159,160,150,149. ZPMC Quality Control Personnel (QC) identified as Mr. Shen jian guo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2114.

This QA observed ZPMC qualified welding personnel identified as 215083 perform Shielded Metal Arc Welding (SMAW) Process on weld joint CB3002K-004-046. ZPMC Quality Control Personnel (QC) identified as Mr.

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Shen jian guo was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-P-2213-B-U2.

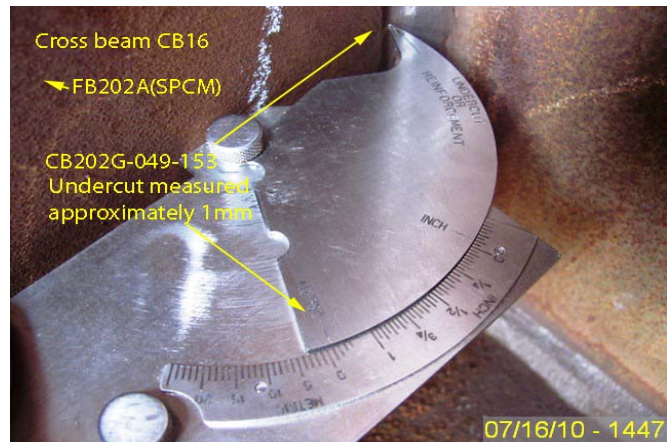
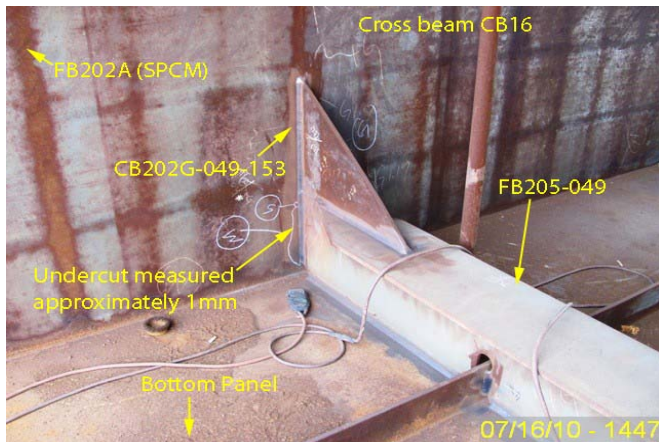
OBG # BAY 7

This QA observed ZPMC qualified welding personnel identified as 048625 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3184-001-003. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-4232-TC-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 051246 perform Flux Cored Arc Welding (FCAW) Process on weld joint DP3165-001-160. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-TC-U4b-F.

This QA observed ZPMC qualified welding personnel identified as 054458 perform Submerged Arc Welding (SAW) Process on weld joint CB3003C-019-005. ZPMC Quality Control Personnel (QC) identified as Mr. Xu hai yang was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2221-B-L2C-S-2

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mention above

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

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Inspected By: Sukanthan,Dhanasingh

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer